

# Work Order ID 72772

Friday, August 12, 2011 2:35:20 PM



Page 1

Item ID: D3875-1

Accept



Setup Start



Revision ID:

Item Name: Floor Protector

Stop



Start Date: 8/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-08-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3875

Rev A

100

0.00

X3

X1

*[Signature]*  
11/08/17



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

*[Signature]*

105

0.00



HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 140°F

X3

X1

*[Signature]*  
11/08/17

Time IN: 4:00 pm 11/08/16

Time OUT: 7:00 am 11/08/17

W/O: 72772		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D38757 PAR #: N/A Fault Category: Thermofuming NCR: Yes ☒ No ☐ DQA: 1A Date: 11-08-22  
 Resolution: Good as is Disposition: Good as is QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <del>72772</del>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11.08.18	110	Width is overtolerance. (45.2 is 45.5) R.C. Process change.	CP 11.08.18 05/042	Acceptable. Part matches prototype part in lab. Problem with dim on drawing. Customer will trim as required	N/A	S 11/08/18	CP 11.08.18 05/042	S 11/08/18

NOTE: Date & initial all entries

**Work Order ID 72772**

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Page 2

Item ID: D3875-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 8/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA0xxusing tool DT9435 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00  0.00				x3 x1			DL 11/08/17
120  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo Visually inspect part for proper formation and texture	0.00  0.00				x3 x1			DL 11/08/17
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				(x3)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




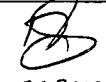

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O: 72772		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3825-1 PAR #: N/A Fault Category: Thermforming NCR: Yes No DQA: A Date: 11.08.22  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 11/8/22

NCR: <del>72772</del>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/08/18	140.	large gouge in Part caused by collet on router. R.C. <del>operator error</del>		Reset collet Scrap & replace. 1 Part m <u>113127</u>	 11/08/18	 11.08.18	 09/24/18	 11.08.18
		Didn't check cutter before use. LOA						

NOTE: Date &amp; initial all entries

# Work Order ID 72772

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Item ID: D3875-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Floor Protector

Start Date: 8/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

PP 72768

11/8/12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/22

11/8/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Friday, August 12, 2011 3:18:19 PM

Page 1

Work Order ID: 72772



Parent Item: D3875-1



Parent Item Name: Floor Protector

Start Date: 8/12/2011


Required Date: 8/19/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 09.02.06 New Issue DL  
Add Step 105 Dry Material 10/04/21 DL

IPP Rev.B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 		Purchased	No			100	sf	1,938.942	9.84	29.52			

Lexan Sheet

Location

Loc Qty

Loc Code

therm

113127

1938.942621

1938.94262

29.52 sf

DL  
11/08/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	72772
<b>Description:</b> Floor Protector		<b>Part Number:</b>	D3875-1
<b>Inspection Dwg:</b> D3875	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

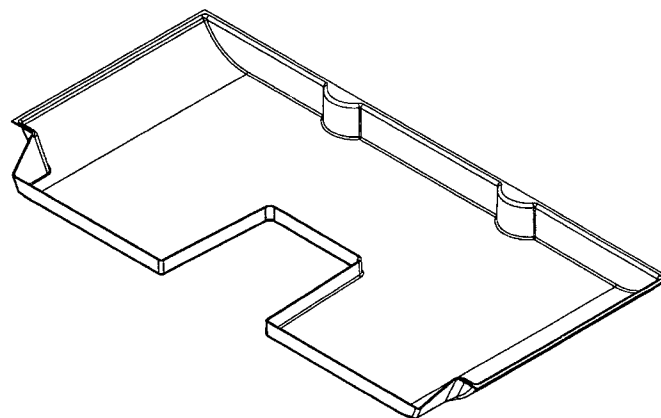
<b>Measured by:</b>	<u>DR</u>	<b>Date:</b>	11/08/17
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### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.053"	✓		ULTRASONIC	
0.080	Min	0.111"	✓		ULTRASONIC	
45.2	+/-0.100	45.5"		✓	TAPE DL-01	Width OK,
21.8	+/-0.100	21.8"	✓		TAPE DL-01	customer trms
1.4	+/-0.100	1.45"	✓		TAPE DL-01	as req'd
						Op 11.08.18
						DR/DR

<b>Measured by:</b>	<u>DR</u>	<b>Date:</b>	11/08/18
<b>Audited by:</b>	<u>DR</u>	<b>Date:</b>	11/08/18
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>DR</u>



**D3875-1 FLOOR PROTECTOR (206B)**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72272

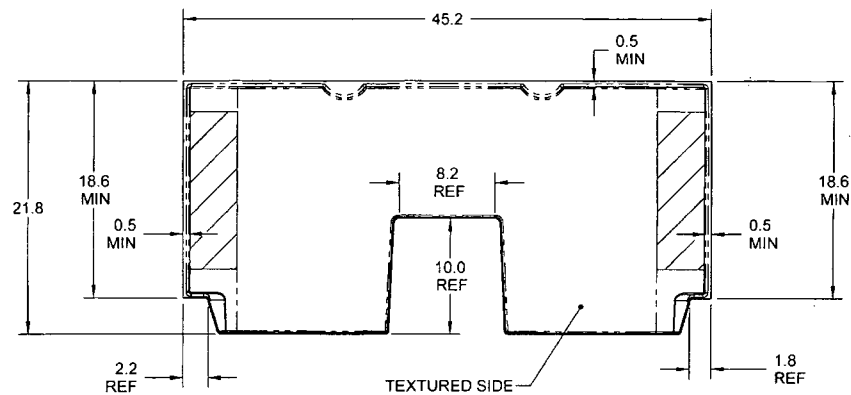
*R1108-12*

**RELEASED**  
*29/05/05*

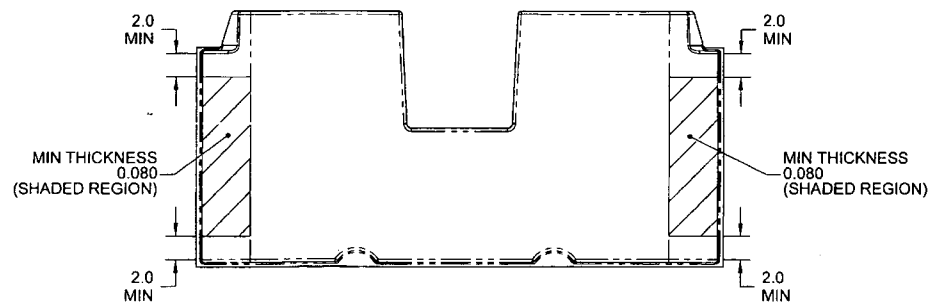
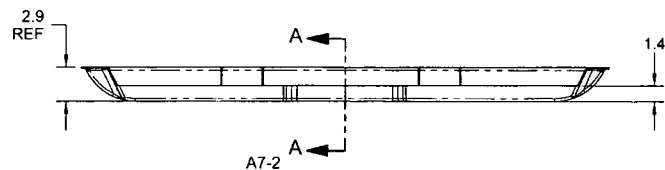
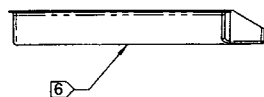
**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3875-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.0 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9475 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>AK</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AK</i>		
CHECKED	<i>LL</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>DS</i>	D3875	SHEET 1 OF 2
APPROVED	<i>AK</i>	TITLE	SCALE
DE APPR.	<i>AK</i>	FLOOR PROTECTOR (206B)	NTS
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72772



SECTION A-A B4-2

D3875-1 FLOOR PROTECTOR (206B)

RELEASED  
09/05/05 MB

DESIGN	Ref	<b>DART AEROSPACE LTD</b>	
DRAWN	Ref	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Ref	DRAWING NO.	REV. A
MFG. APPR.	Ref	D3875	SHEET 2 OF 2
APPROVED	Ref	TITLE	SCALE
DE APPR.	Ref	<b>FLOOR PROTECTOR (206B)</b>	
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